

Work Order ID 73881

Friday, September 16, 2011 3:25:55 PM

Page 1

Item ID: D206-642-151

Revision ID:

Item Name: Replacement Skidtube

Start Date: 9/16/2011 Start Qty: 1.00

Required Date: 10/21/2011 Req'd Qty: 1.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3804

A

IIN-D206-642

O

100

0.00

DC

0.00

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP D206-642-151

CHG001

N/A

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Item ID: D206-642-151

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Revision ID:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch
A/R ☐ Aluminum Rod ☒ M12860

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt8166 & DT8169D & DT9771.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.

MO/D

11-9-20

BE 11/09/20

11-9-20

MO/11

11-9-21

11/09/22

11-9-26

Dart Aerospace Ltd

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DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

16- Open Aft cap hole #6.
****no wearplate holes for this skidtube****

17-Deburr tube and blow out chips from inside the tube

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

8/16/27

11-9-26

11/09/27

Dart Aerospace Ltd

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Dart Aerospace Ltd

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

180



Skidtubes

Skidtubes

Skidtubes

Memo

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required

0.00

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12

Hrs. cure time before cutting

Start Date: ☐ 11/09/2011 Time: ☐Finish Date: ☐ 11/10/2011 Time: ☐ 12:30

Pick:

Qty ☐ Part Number ☐ Description ☐ BatchA/R ☐ Sikaflex-291 ☐ 110393 ☐Sikaflex expire date: ☐ 12/04/05

DP

11-9-28

DL 11/09/2011

DL 11/09/2011

Dart Aerospace Ltd

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Customer:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11-9-29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

0.00



Skidtubes

Skidtubes

Memo

0.00

1-remove alodine from around hole and prepare for welding

*de/DP**11/07/29*

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty ☐ Part Number ☐ Description ☐ BatchA/R ☐ Aluminum Rod ☐*m117884**BE 11/10/03*

3-Grind welds flush as per Dwg D3804.

*B**11/10/04*

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/R ☐ SS Rod ☐*None*

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

*E. / PMB 10/10/04**DP**11-10-5*

Dart Aerospace Ltd

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Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

Install D2680-041 Nut Plate as per Dwg D3804

11-10-5

220

0.00



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

Qc9

8.11.10.06

11.10.05

230

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

8.11.10.06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
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Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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240

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

250

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:00
320 OF
3:30

260

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 XPM 11/10/06

1 p 11/10/07

Dart Aerospace Ltd

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Setup Start

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

270

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install
plugs as per Dwg D3804. Clean excess adhesive.

1 RH / 11/10/07

280

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

A/R ☐ Sikaflex-291 ☐ 11/11/03 ☐Sikaflex expire date: ☐ 12/05

2- Install wearplate as per dwg

2-Wing Walk as per Dwg D3804 and QSI 005 4.4 ☐

Batch: _____

1 RH / 11/10/11

Dart Aerospace Ltd

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

290

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

300

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

310

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-151

Location:

PPP Rev: PPA 74413

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
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DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

320

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/18 [Signature]
mf
11-10-18

Dart Aerospace Ltd

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Picklist Print

*Friday, September 16, 2011 3:25:51 PM

Page 1

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Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV.N DD VERF:EC
REV:B 11.09.16 PER IIN REV.O DD VERF:EC

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2620

Manufactured No

110

Each

12.0000

1

1



Skidtube, 206 Skidtube

Location

Loc Qty

Loc Code

LG 73781
68136
71616
71617

12
1
5
6

1

mo ~~D~~ 11-9-20

D2647

Manufactured No

110

Each

44.0000

1

1



Cap

Location

Loc Qty

Loc Code

LG002
55352
71171

44
14
30

8/21/09/20

CR3212-4-04

Purchased No

180

Each

1,655.000

52

52



Cherry Rivet

Location

Loc Qty

Loc Code

ST311
116471
117816
118686
118840

1655
78
477
100
1000

55

Ob
11/09/20

Dart Aerospace Ltd

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Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

D2654-1 Manufactured No

180 Each

6.0000

1 1



Web

Location

Loc Qty

Loc Code

LG

73789
64562

6

6

1

2

D3286-1 Manufactured No

180 Each

32.0000

2 2



Doubler

Location

Loc Qty

Loc Code

LG002

32

52844

11

64563

21

D2649 Manufactured No

200 Each

289.0000

19 19



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

6

68224

2

71355

2

72704

2

LG001

283

65317

1

68507

11

73390

271

D3286-3 Manufactured No

200 Each

27.0000

2 2



Spacer

Location

Loc Qty

Loc Code

LG002

27

64564

27

11/09/28

11-9-26

BE 11/10/03
B 73857 ~19

11/10/04

Friday, September 16, 2011 3:25:52 PM

Shop Packet Print

Page 2

Dart Aerospace Ltd

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Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

D2680-041

Manufactured No

210

Each

19.0000

1

1



Nut Plate



SAO 11-10-05

Location

Loc Qty

Loc Code

ST020

19

55366

17

70088

2

B73334

CR3212-4-03

Purchased No

210

Each

1,138.000

2

2



Cherry Rivet



SAO 11-10-05

Location

Loc Qty

Loc Code

FP-B

2

110139

2

ST311

1136

114859

1136

AN960JD416

NAS1149D0463J

Purchased No

210

Each

0.0000

1

1



Washer

M118384



(x1) 11-10-05

CCR264SS3-3

Purchased No

210

Each

435.0000

2

2



Cherry Rivet



Location

Loc Qty

Loc Code

FP-B

2

113973

2

ST311

433

117086

23

117849

410

2 DP 11-10-05

Friday, September 16, 2011 3:25:52 PM

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Page 3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 4

Work Order ID: 73881

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

210

Each

29.0000

1

1



Screw



11/10/07

Location

Loc Qty

Loc Code

FP-A

8

115460

8

ST292

21

115460

21

D2651-1

Manufactured

No

270

Each

289.0000

6

6



Plug



11/10/07

Location

Loc Qty

Loc Code

fpa

109

69018

109

FP-A

180

57869

1

66445

10

67760

36

70691

100

70839

2

71037

31

x 6

D2651-3

Manufactured

No

270

Each

799.0000

6

6



O-Ring



11/10/07

Location

Loc Qty

Loc Code

FP-A

799

61962

12

66956

282

73489

505

x 6

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Page 4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 5

Work Order ID: 73881

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

D3873-1

Manufactured No

280

Each

160.0000

14

14



Bushing



xl

u/10/07

Location

Loc Qty

Loc Code

ST084

4

B 73829

xl

68247

4

ST088

156

64760

1

70690

54

71837

101

D2646

Manufactured No

280

Each

89.0000

1

1



Aft Cap



xl

u/10/07

Location

Loc Qty

Loc Code

FP004

45

68280

45

FP006

5

62678

5

FP-4

35

70945

1

71070

34

fp5

4

xl

71038

4

D3805-041

Manufactured No

280

Each

0.0000

1

1



Wearplate Assembly Fwd, Low Gear



(v) xl

u/10/07

B 73770

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Page 5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 73881

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08

Purchased

No

280

Each

1,296.000

2

2



yl 11/10/07

Screw

Location

Loc Qty

Loc Code

ST291

1296

115108

96

117423

300

118378

400

118910

500

x2

MS21042L3

Purchased

No

280

Each

2,603.000

7

7



yl 11/10/07

Nut

Location

Loc Qty

Loc Code

ST300

2603

117441

24

117601

374

117885

205

118451

1000

118927

1000

x7

D3805-045

Manufactured

No

280

Each

6.0000

1

1



(x1) yl 11/10/11

Wearplate Assembly Aft, Low Gear

Location

Loc Qty

Loc Code

FP

6

70878

6

AN960JD10L

NAS1149D0332J

Purchased

No

280

Each

0.0000

2

2



yl 11/10/07

Washer

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Page 6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 7

Work Order ID: 73881

Parent Item: D206-642-151


Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-37A Purchased No 280 Each 261.0000 7 7

 Bolt

Location Loc Qty Loc Code


ST353 211

111668 111

118628 100

ST354 50

117619 50

NAS1149D0363J Purchased No 280 Each 2,623.000 7 7

 Washer

Location Loc Qty Loc Code

ST298 2623

117601 308

118077 1315

118612 1000

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Page 7

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

73881

RELEASED
UP 09.03.03
PER ECN 09-530

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	93		
DRAWN	93		
CHECKED	93		
MFG. APPR.	93		
DE APPR.	93		
DATE	08.07.07		

DART AEROSPACE USA, INC	
PORT HADLOCK, WA	
DRAWING NO.	REV. A
D3804	SHEET 1 OF 5
TITLE	SCALE
SKIDTUBE ASSEMBLY, 206A/B	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Dart Aerospace Ltd

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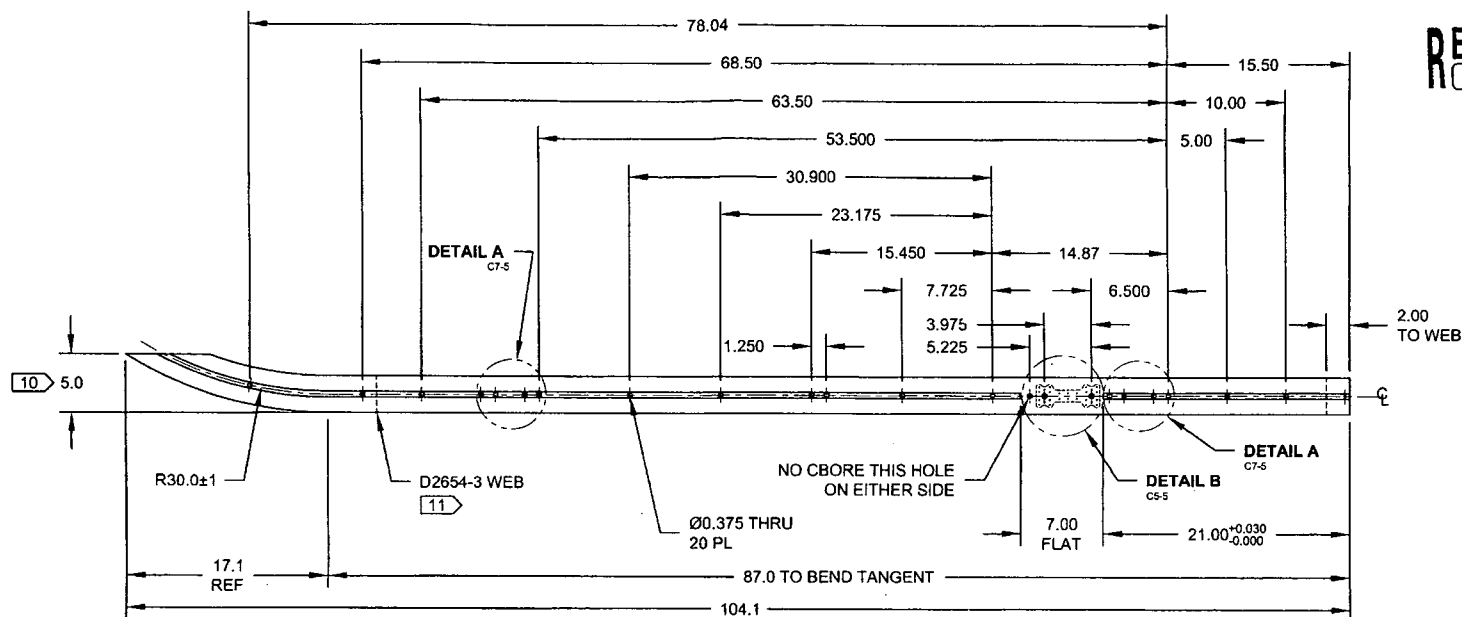
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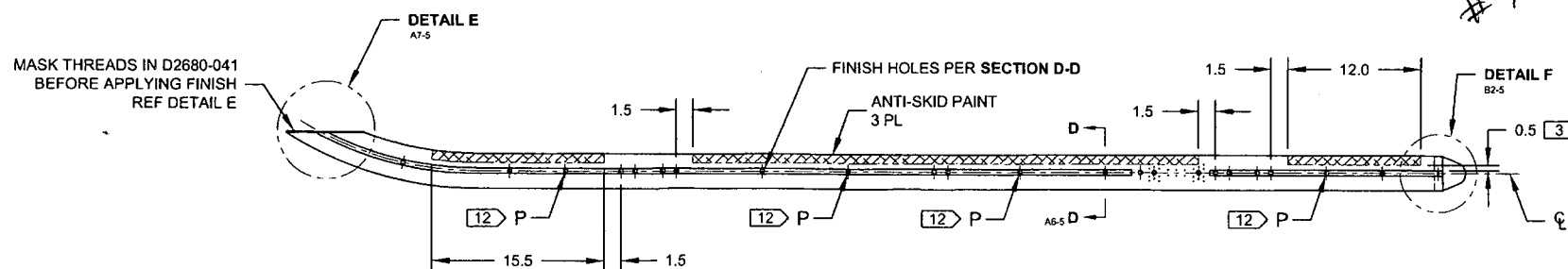
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
(09-03-07)



D3804-043 BENDING/DRILLING DETAIL



D3804-043 ASSEMBLY/FINISHING DETAIL

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 3 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
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#73881

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

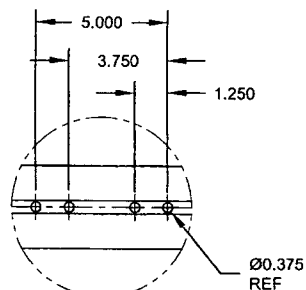
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

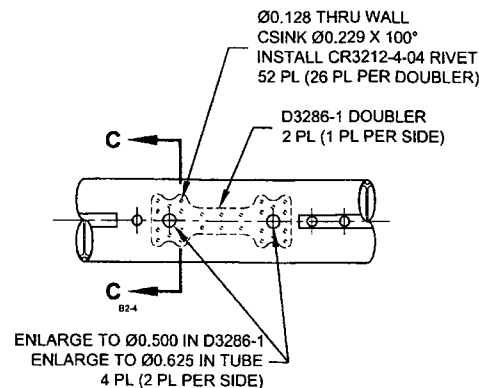
NOTE: Date & initial all entries

RELEASED
CP 09.03.09



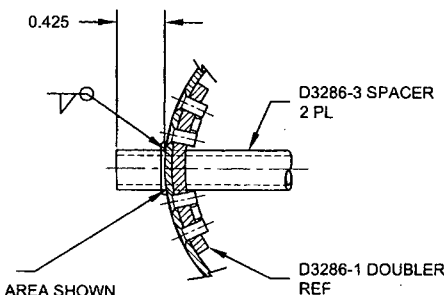
DETAIL A
SCALE NONE

D6-2
C2-2
D6-3
C2-3



DETAIL B
SCALE NONE

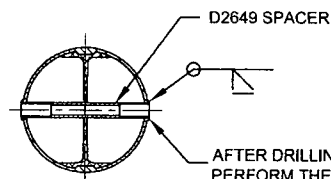
C3-2
C3-3



- TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C
PARTIAL SECTION
SCALE NONE

C6-4



- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

SECTION D-D
FOR Ø0.375 HOLES ONLY
SCALE NONE

A4-2
A4-3

DESIGN	99	DART AEROSPACE USA, INC	
DRAWN	99	PORT HADLOCK, WA	
CHECKED	99	DRAWING NO.	REV. A
MFG. APPR.	99	D3804	SHEET 4 OF 5
APPROVED	99	TITLE	SCALE
DE APPR.	99	SKIDTUBE ASSEMBLY, 206A/B	NTS
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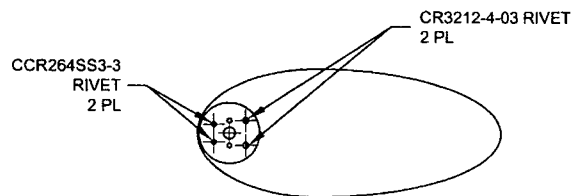
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

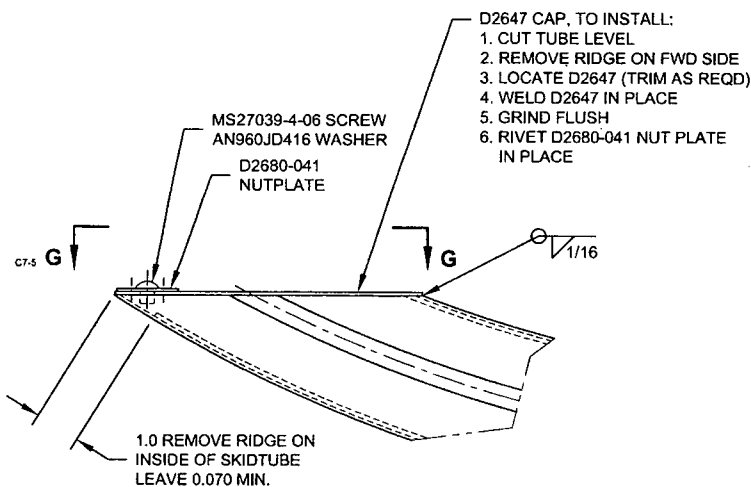
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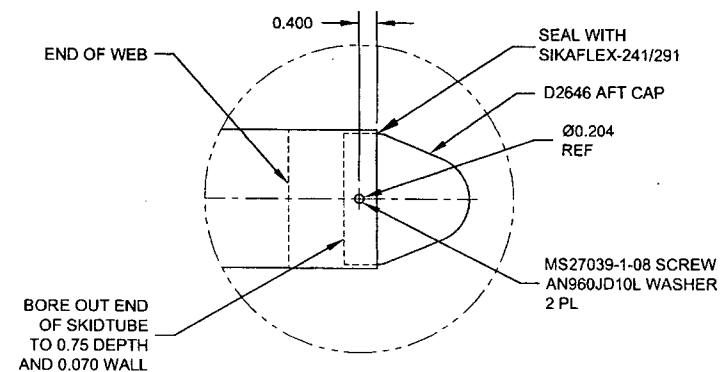
RELEASED
09-03-07



VIEW G-G
SCALE NONE A7-5



DETAIL E
SCALE NONE B7-2 B7-3



DETAIL F
SCALE NONE B2-2 B2-3

#73581

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 5 OF 5
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DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
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NO. 266

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 704089
Part number: A206 642 151
Description: 206
Welding Process: Tig[☒] Mig[]
Base material: Chromium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat Jones Date of Test Coupon 11-09-22

Welder Barclay Elliott Date of Test Coupon 11-09-22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld